

Work Order ID 63692

November 10, 2010 9:07:37 AM



Page 1

Item ID: D4015-1

Accept



Setup

Start



Revision ID:

Item Name: Wearbar

Stop



Start Date: 11/10/10 Start Qty: 70.00



Cust Item ID:

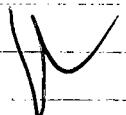
Required Date: 11/15/10 Req'd Qty: 70.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4015

B

100

0.00



Waterjet

Memo

0.00

810-11-10

FLOW CNC Waterjet

I-Cut as per Dwg D4015

Dwg Rev:

Prog Rev:

2-Deburr if necessary

72

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

810-11-10

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63692

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Page 2

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Revision ID:

Item Name: Wearbar

Stop



Start Date: 11/10/10 Start Qty: 70.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 70.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____ Tooling: _____

Date: _____

Run

Start



QC:

Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S. volu

counts
F72

130



Brake NC

Brake NC

Form as per dwg

0.00

Memo

0.00

Use DT9541 forming tool

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S. volu/17

counts
F72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63692

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Item ID: D4015-1

Accept



Setup

Start



Revision ID:

Item Name: Wearbar

Stop



Start Date: 11/10/10 Start Qty: 70.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 70.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: W/0Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/23

MF

10-11-23

63690

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2010 9:07:13 AM

Page 1

Work Order ID: 63692



Parent Item: D4015-1



Parent Item Name: Wearbar

Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 70.00

Required Qty: 70.00

Comments: IPP RevA: New issue 09.10.28 verified by:JLM
remove welding 09.11.03 DD verified by:EC
dwg 09.11.18 DD verified by:JLM

IPP RevB:
IPP RevC: revB as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	170.6000	0.0095	0.7		11/10-11-16	

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT	170.6	
111323	0	
115688	10.6	115688
115953	160	

(72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63692
Description: WEAR BAD	Part Number:	D4015-1
Inspection Dwg: D4015-1, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

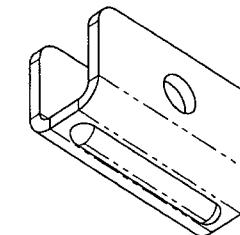
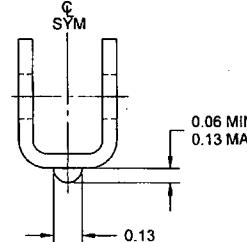
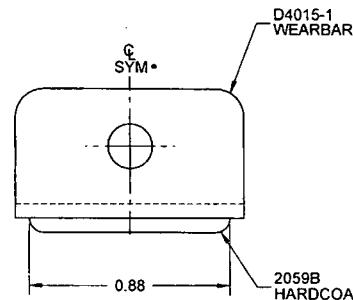
X First Article **X** Prototype

Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval: _____
Date: <u>10-11-10</u>	Date: <u>10/11/11</u>	Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	1	D4015-041	WEARBAR WELDMENT
11	1	D4015-1	WEARBAR
21	A/R	2059B	HARDCOAT



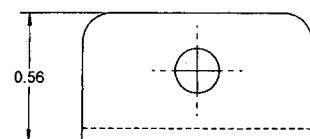
D4015-041 WEARBAR WELDMENT

W 063692

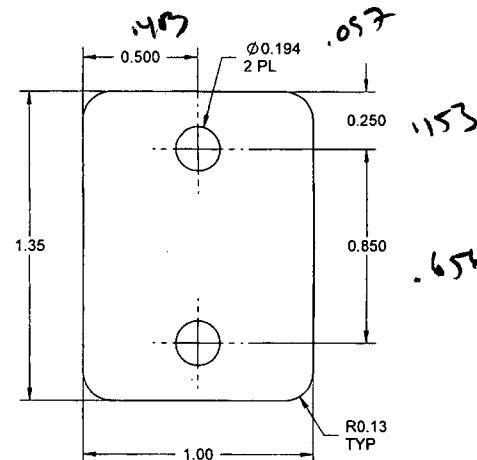
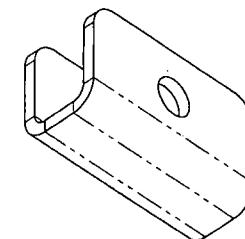
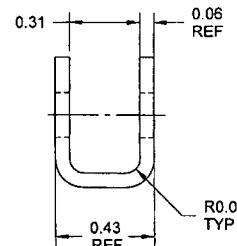
RELEASED
2009-11-24

B	CHANGED COLOR TO BLACK SANTEX	MB	09.11.13
A	NEW ISSUE	MB	09.10.23
REV.	DESCRIPTION		
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4015	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARBAR WELDMENT	NTS
DATE	09.11.13	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE SECRET INFORMATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

NOTES:
 1) MATERIAL: SEE SHEET 2 FOR D4015-1
 2) FINISH: POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3 
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.02 lbs
 8) WELDING: PER DART QSI 004



D4015-1 WEARBAR
MAKE FROM D4015-1



D4015-1F WEARBAR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	<i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AB</i>		
CHECKED	<i>FJS</i>	DRAWING NO.	REV. 8
MFG. APPR.	<i>AB</i>	D4015	SHEET 2 OF 2
APPROVED	<i>AB</i>	TITLE	SCALE
DE APPR.	<i>AB</i>	WEARBAR WELDMENT	NTS
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63692
RELEASED
2009-11-26
AB